

## 120SX

27.08.20

### STANDARD 2K CLEAR®

#### DESCRIPTION

2-component clear to be used in clear over base system.  
Composition based on acrylic copolymer.

#### PRODUCTS

|       |                          |
|-------|--------------------------|
| 120S  | Standard 2K Clear®       |
| 125S  | Standard Activator       |
| 255MS | Universal Fast Activator |
| 256S  | Activator Fast           |
| AK260 | High Solids Activator    |

#### PROPERTIES

- Has very good flow.
- Has excellent mar, chemical and weather resistance.
- Gives a long lasting high gloss finish.
- Can be used for spot, panel and overall repair.

#### SUBSTRATES










- Axalta solvent borne basecoats.
- All cleaned and sanded OEM finishes (not recommended on thermoplastic acrylic finishes).

## 120SX

27.08.20

### STANDARD 2K CLEAR®

#### PRODUCT PREPARATION

|  |                             |   |                         |                  |                  |                  |  |                  |
|--|-----------------------------|---|-------------------------|------------------|------------------|------------------|--|------------------|
| <br>   | <b>Mixing Ratio</b>         |   | <b>Standard</b>         |                  | <b>Fast</b>      |                  | <b>Large surface</b>                   |                  |
|  |                             | 120SX<br>125S / 255MS<br>256S<br>AK260  | Volume<br>Weight        | Volume<br>Weight | Volume<br>Weight | Volume<br>Weight | Volume<br>Weight                       | Volume<br>Weight |
|  |                             |   | 2<br>100                | 3<br>100         | 4<br>100         |                  |  |                  |
|  |                             |   | 1<br>50                 | -<br>-           | -<br>-           | -<br>-           | -<br>-                                 | -<br>-           |
|  |                             |   | -<br>-                  | 1<br>35          | -<br>-           | -<br>-           | 1<br>27                                | -<br>-           |
|  |                             |   | -<br>-                  | -<br>-           | -<br>-           | -<br>-           | -<br>-                                 | -<br>-           |
|  | <b>VOC</b>                  |   | 602 g/l                 |                  | 598 g/l          |                  | 589 g/l                                |                  |
|   | <b>Pot life @20°C</b>       | 125S<br>255MS<br>256S   | 6 h<br>5 h<br>4 h       |                  |                  |                  |  |                  |
|    | <b>Spray Viscosity 20°C</b> | <b>DIN 4<br/>FORD 4</b>   | 15 – 16 s<br>15 – 16 s  |                  |                  |                  |  |                  |
|   | <b>Spray Equipment</b>      | <b>Conventional Guns</b><br>Gravity feed<br>Suction feed<br>Pressure feed           | <b>Fluid Tip</b>        |                  | <b>Distance</b>  |                  | <b>Pressure</b>                        |                  |
|  |                             |   | 1.4 – 1.6 mm            |                  | 15 – 20 cm       |                  | 3-4 bar                                |                  |
|  |                             | 1.6 – 1.8 mm  |                         | 15 – 20 cm       |                  | 3-4 bar          |  |                  |
|  |                             | 1.0 – 1.2 mm  |                         | 15 – 20 cm       |                  | 3-4 bar          |  |                  |
|  |                             | <b>Compliant Guns (HVLP / HTE)</b><br>Gravity feed<br>Suction feed<br>Pressure feed | 1.3 – 1.5 mm            |                  | 10 – 15 cm       |                  | According to supplier's specifications |                  |
|  |                             |   | 1.5 – 1.6 mm            |                  | 10 – 15 cm       |                  |  |                  |
|  |                             |   | 1.0 – 1.2 mm            |                  | 10 – 15 cm       |                  |  |                  |
|  |                             |   |                         |                  |                  |                  |  |                  |
|   | <b>Number of Coats</b>      | 2 - 3   |                         |                  |                  |                  |  |                  |
|   | <b>Flash time</b>           | 10 min between coats<br>5 min before bake   |                         |                  |                  |                  |  |                  |
|  | <b>DFT</b>                  | 40 – 50 µm (2 coats)  |                         |                  |                  |                  |  |                  |
|   | <b>Drying</b>               | <b>Dust-free<br/>Dry to handle<br/>Tape-free</b>                                    | <b>125S/AK260/255MS</b> |                  | <b>256S</b>      |                  |  |                  |
|  |                             |   | 20°C                    | 30 min@60°C      | 20°C             | 20 min@60°C      |  |                  |
|  |                             | 40 min  |                         | imm.             |                  | 30 min           |  | imm.             |
|  |                             | 6 hr  |                         | 30 min           |                  | 4 hr             |  | 30 min           |
|  |                             | O.N.  |                         | 1 hr 30 min      |                  | 5 hr             |  | 1 hr 30 min      |
|   | <b>IR Drying*</b>           | Flash time  | 5 min                   |                  |                  |                  |  |                  |
|  |                             | Distance  | 80 cm                   |                  |                  |                  |  |                  |
|  |                             | Half power  | 5 min                   |                  |                  |                  |  |                  |
|  |                             | Full power  | 15-20 min               |                  |                  |                  |  |                  |
| * Guideline for short/medium wave IR equipment.  |                             |   |                         |                  |                  |                  |  |                  |
| This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use. |                             |   |                         |                  |                  |                  |  |                  |

## 120SX

27.08.20

### STANDARD 2K CLEAR®

#### SURFACE PREPARATION

- 1 Clean surface with water and soap. Rinse and dry.
- .
- 2 Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
- .
- 3 Repair according to damage.
- .
- 4 Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
- .
- 5 Tack rag.
- .
- 6 Apply an Axalta basecoat.
- .

#### CLEARCOAT APPLICATION

When the basecoat is completely flat, apply 120SX in 2 to 3 coats with 10 min flash between coats.

#### CHEMICAL RESISTANCE

When fully cured, 120SX is resistant to short exposures of the chemicals as listed:

|                   |      |                     |
|-------------------|------|---------------------|
| sodium hydroxide  | 20 % | battery acid        |
| sulphuric acid    | 25 % | toluene             |
| hydrochloric acid | 20 % | xylene              |
| phosphoric acid   | 20 % | glycol              |
| ammonia           | 10 % | brake fluid, petrol |

#### EQUIPMENT CLEANING

Use a correct solventborne gunwash.

## 120SX

27.08.20

### STANDARD 2K CLEAR®

#### RECOATABILITY

At any time after tape-free time. After 24 hr, scuff sanding is required.

#### REMARKS

- 256S is recommended for spot repair only.
- If necessary for minor viscosity adjustments, use Centari® basecoat thinners (maximum 5 %).
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Activated material should not be returned to original can of non-activated material.
- To spray interiors, use of 431R or 256S is recommended.
- Dry spray spots in the clear can be worked off with AK350 at very low spray pressure. This should be done at the latest 10 min after clear application and should be avoided on horizontal parts.
- For structured and/or flat clears, see specific TDS.
- For flexible systems, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

#### PRODUCT DATA

|                       |  |
|-----------------------|--|
| Package viscosity:    | 70 - 80 cp   |
| Theoretical coverage: | 5.7 m <sup>2</sup> /l at recommended DFT - ready-to-spray. |

#### SAFETY

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

## 120SX

27.08.20

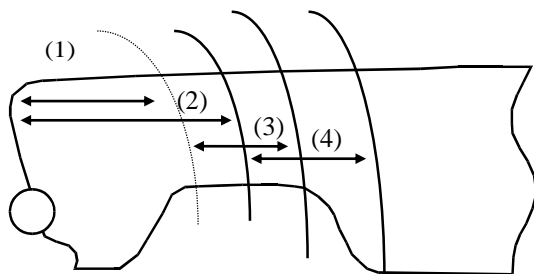
### STANDARD 2K CLEAR®

#### OVERALL REPAIR

Pay attention to the application method. Spray procedure has to ensure proper overspray melt-in which is achieved within 2 min of the clear application. Plan the process to avoid dry overspray.

#### SPOT REPAIR: AK350 FADE-OUT THINNER METHOD

- (1) Apply 1 coat of 120SX over the basecoat, extending into the area surrounding the spot.
  - (2) Apply a 2nd coat of 120SX, extending further into the area surrounding the spot.
  - (3) OPTIONAL: Reduce 1 part of 120SX with 1 part AK350 and apply 1 coat of reduced 120SX over the fade-out area.
  - (4) Blend in the fade-out area immediately with pure AK350.
- ! Surface should be carefully and correctly prepared before the basecoat application.  
See recommended use, paragraph surface preparation
- ! Apply AK350 within the prepared area.



If necessary, balance out the gloss level by polishing with a non silicone containing polishing compound or a non silicone containing final glaze, after complete hardening of the repair.

## 120SX

27.08.20

**STANDARD 2K CLEAR®**

All other products referred to in the paint system build-up are from Cromax®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax®, unless explicitly indicated otherwise.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.